	er ID 74595 r 03, 2011 3:58:54 PM	0								Page 1
Revision ID:	D3536-25 Gasket	SAV	Accept				s	etup Star Stop		
Start Date: Required Date: Reference:	10/3/2011 Start Qty: 12.0 10/5/2011 Req'd Qty: 12.0			Cust Item I Customer:	D:					
	Process Plan:	Date: //-/0-04	Tooling: _ SPC (Y/N):		ate:		R	un Star Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								· ·	
D3536	Rev A									
Waterjet FLOW CNC Waterjet		per Dwg D3536 □Dwg Rev Tnecessary	0.00 0.00 :A□Prog Rev:_				<u></u>	(<u>- 10-((</u>		2)
QC Quality Control	QC2- Inspect parts of Memo	f machine FAI/FAIB	0.00				B	(-10-11		
120 	QC8- Inspect parts - s	second check	0.00	olu			(HZ)		:

Quality Control

W/O:			WO	RK ORDER CHANGES			. <u>-</u>		
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory: I	NCR: Yes	No DQ	A:	Date: _	
	Re	solution:	Disposition	:	QA: N/C (losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NC	R)			
DATE	STEP	Description of NC			Section B		cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	tion C	Chief Eng	QC Inspector

Work Order ID 74595

Monday, October 03, 2011 3:58:54 PM



Page 2

Item ID:

D3536-25

Accept



Setup Start

Run

Stop



Revision ID:

Start Date:

Item Name:

Gasket

10/3/2011

Start Qty: 12.00 Req'd Oty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _

Tooling:

Date:

Tool ID

Code

Start Stop



Required Date: 10/5/2011

QC:

Operation

Description

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan Accept

Qty

Reject Qty

Reject Insp. Number Stamp

Sequence ID/ Work Center ID

130

Packaging

0.00

Memo

Identify as per dwg & Stock Location

0.00

Packaging

140

QC Quality Control QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			WO	RK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	ory:	_ NCR	: Yes 1	No DQ	A:	Date:	
	Re	solution:	Disposition	·	QA:	N/C Clo	sed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			Verification &			Approval	Approval
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Picklist Print

Monday, October 03, 2011 3:58:58 PM

Work Order ID: 74595

Parent Item:

D3536-25

Parent Item Name: Gasket



Start Date: 10/3/2011

Required Date: 10/5/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	636.8500	0.5956	7.941333	9	} -	
										R	11-10-1		

NEOPRENE SHEET 0.063

	•			
Location	Loc Oty	Loc Code		`
MAT052	636.85			6-
117295	55.68			· IJ -
118026	127.87			_
118663	73.3		118663	
119130	380		<u> </u>	

W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	By	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Y	es N	o DQ	A:	Date: _	
	R	esolution:	Disposition	:	_ QA: N/	C Clos	sed:		Date: _	
NCR:	· · · · · · · · · · · · · · · · · · ·		WORK ORDE	R NON-CONFORM	ANCE (N	ICR)				
DATE	OTED	Description of NC			ection B Ver			ation	Approvál	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Secti		Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	74595
Description: Gasket	Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80			T BU	
16.35	+/-0.030	16.35	1		7	
10.90	+/-0.030	10.90	5		τ	
5.45	+/-0.030	5.40	8	-	τ	
6.00	+/-0.030	60.0	2		7	
6.75	+/-0.030	6.75	>		7	•
12.75	+/-0.030	12:22	⋈		†	
1.89	+/-0.030	1.890	ید		V B02	
0.30	+/-0.030	1361	C		V	
0.30	+/-0.030	1304	7		V	
Ø0.19	+0.005/-0.001	,(90	2		V	

Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	11-10-11	Date: ulcolu	Date:	N/A
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Rev	Date	Change		Revised by	Approved
Α	07.06.13	New Issue	·	KJ/JLM	R

	Topado								
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	QA: N/C C	losed:		Date: _		
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		Description of NC	Description of NC Corrective		on B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	on C	Chief Eng	QC Inspector

DATE 96.

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GASKET

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NEW ISSUE

CHECKED

D3536 DRAWING NO.

SHEET 1 OF

SCALE

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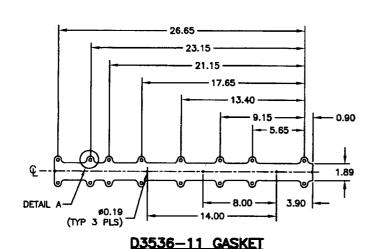
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	14.00
(TYP 4 PLS)	20.00
	D3536-13 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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W/O:			WORK ORDER	CHANGES					
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC inspecto
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PURPOSE

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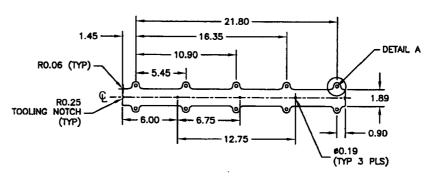
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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

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DATE	STEP	Description of NC		Corrective Action	Section B			cation	Approval	Approval
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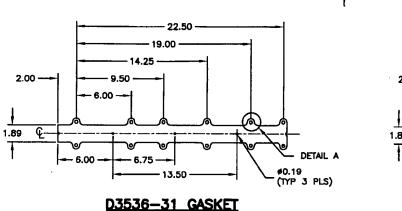
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D3536-33 GASKET

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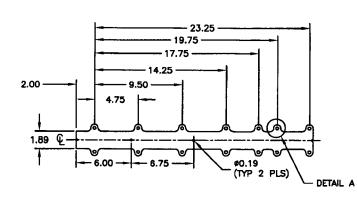
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욹 COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
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- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-35 GASKET

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W/O:			WO	RK ORDER CHANGI	ES				
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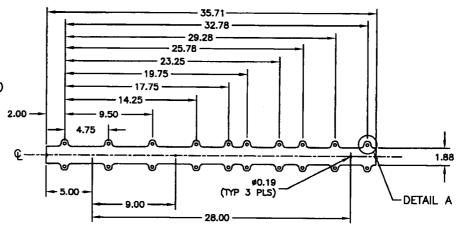
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PURPOSE

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- TERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEOBO-S.063)
- 2) FINISH: NONE
- PART IS SYMMETRICAL ABOUT ©
 TOLERANCES ARE PER DART QSI 018 UNLESS
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- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



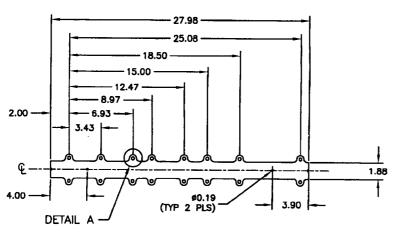
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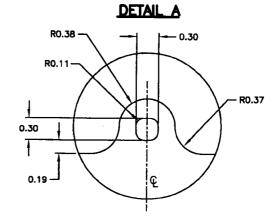


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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
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